

# Work Order ID 58896

May 20, 2010 10:48:32 AM



Page 1

Item ID: D3780-041

Accept



Setup Start



Revision ID:

Item Name: Armrest Assembly

Stop



Start Date: 5/19/10 Start Qty: 6.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3780

Rev D

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

DISASSEMBLE 6 X D3780-041 B56891  
KEEP PARTS TO REASSEMBLE

*SP 10/06/01*

BRING D3696-041 TO MANUAL MILL

*6*

101

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

DRILL/COUNTERSINK HOLES PER DRWG D3696 REV.D, PER ECN10-573

*B.A 10/06/15*

*6 0*

102

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B.A 10/06/15*

*6 0*

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Page 2

Item ID: D3780-041

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Setup Start



Revision ID:

Stop



Item Name: Armrest Assembly

Start Date: 5/19/10 Start Qty: 6.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

103

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

ant 10/06/15

4 5

Quality Control

104

0.00



Small Fab

Memo

0.00

Small Fab

REASSEMBLE, USING ORIGINAL PARTS PER DRWG D3780

9510/06/16 (6)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sid 06/16

(76)

Quality Control

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Page 3

Item ID: D3780-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Armrest Assembly

Start Date: 5/19/10 Start Qty: 6.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



Packaging

Identify as per dwg & Stock Location 185

0.00

Memo

0.00

Packaging

RE-IDENTIFY USING NEW B/N

11-6-18 SP Q

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/21 MFMF 10-6-21

# Picklist Print

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Page 1

Work Order ID: 58896



Parent Item: D3780-041



Parent Item Name: Armrest Assembly

Start Date: 5/19/10

Required Date: 5/28/10

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec  
IPP Rev:B 08-07-22 revB as per dwg verified by:EC  
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D3780-041		Manufactured	No				Each	6.0000				



Armrest Assembly



*EP 5/10/06/16*

Location

Loc Qty

Loc Code

ST261

6

56891

6

6

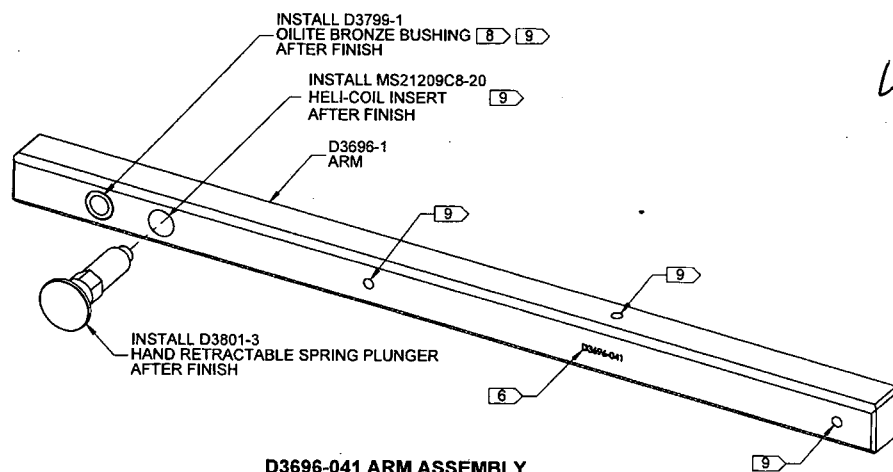
MS24665-302  
cotter pin

QTY=6 M113644

*EP 5/10/06/16*



ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3696-041	ARM ASSEMBLY
5	1	D3696-1	ARM
6	1	D3799-1	OILITE BRONZE BUSHING
7	1	D3801-3	HAND RETRACTABLE SPRING PLUNGER
11	1	MS21209C8-20	HELI-COIL, SCREW LOCKING (RED)



**D3696-041 ARM ASSEMBLY**

**RELEASED**  
2010-05-17  
MD

**D3696-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDOMEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3696-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 1.68 lbs
- 8) FACE D3799-1 OILITE BRONZE BUSHING FLUSH TO D3696-1 ARM AS REQUIRED ON BOTH SIDES PRIOR TO POWDER COATING
- 9) MASK HOLES AS SHOWN PRIOR TO POWDER COATING

D	REVISED ITEM 5 AS FOLLOWS: Ø0.201 THRU CBORE Ø0.500 X 0.300 DP' NOW 2 PL (ZN C4-2 AND B4-2). REASON: ADDITION OF ALTERNATE ARMREST INSTALLATION D412-761-051 BASED ON FEEDBACK FROM END USERS AT HAI 2010	MB	10.05.06
C	REVISED ITEM 5 AS FOLLOWS: Ø0.201 THRU CBORE Ø0.500 X 0.300 DP' WAS 2 PL (ZN C4-2). REASON: REDESIGNED ARMREST CUSHION BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.06.17
B	P/N D3799-1 WAS BNT-137 (ZN D6-1); P/N D3801-3 WAS PRT-12 (ZN C7-1). REASON: PURCHASED PARTS NOW PROCURED THROUGH D3799 AND D3801 SPEC CONTROL DRAWINGS; ADDED Ø0.201 HOLE AND CBORE (ZN C6-2 AND D5-2); 17.50 WAS 19.50 (ZN B5-2); 1.000 WAS 0.990 +0.000/-0.010 (ZN C2-2). POCKETS REMOVED REASON: ELIMINATED FWD-AFT ARMREST ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	1		
MFG. APPR.	1		
APPROVED	1		
DE APPR.	1		
DATE	10.05.06		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3696

REV. D

SHEET 1 OF 2

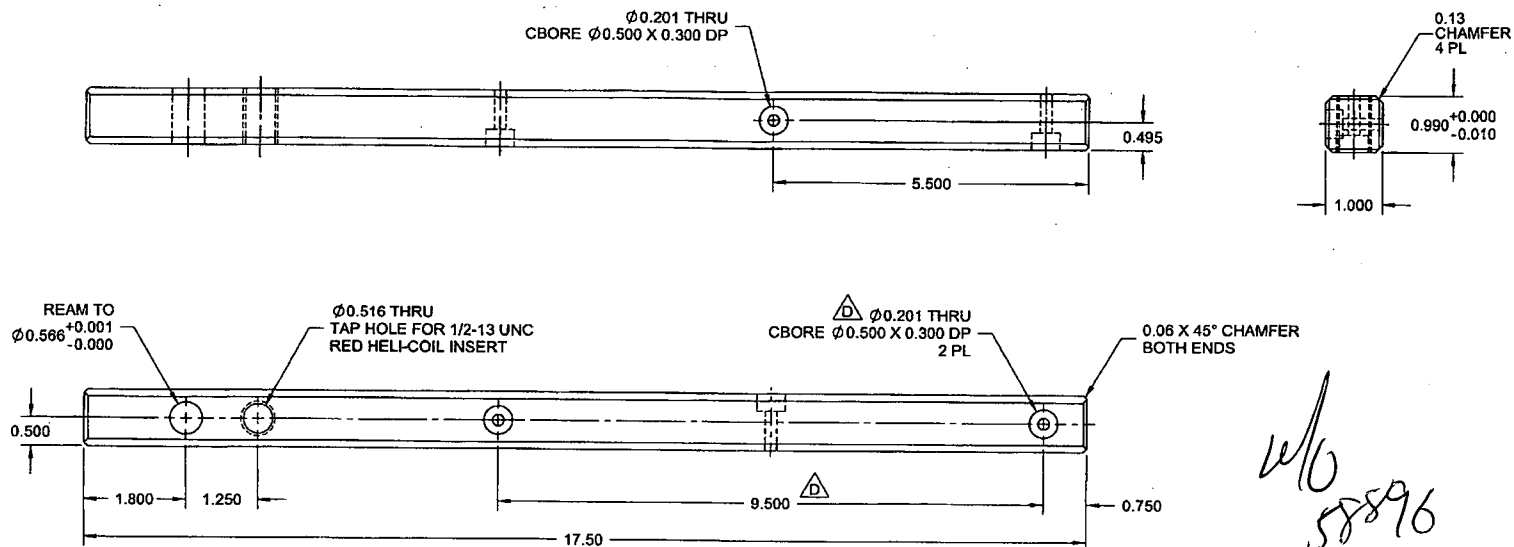
TITLE

ARM ASSEMBLY

SCALE

NTS

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**D3696-1 ARM**

**RELEASED**  
2010-05-13  
NW

**D3696-1 NOTES:**

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR  
PER AMS-QQ-A-200/11  
REF. DART SPEC. M7075T6B
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.62 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3696</b>	REV. D
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE <b>ARM ASSEMBLY</b>	SCALE
DE APPR.			NTS
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8

7

6

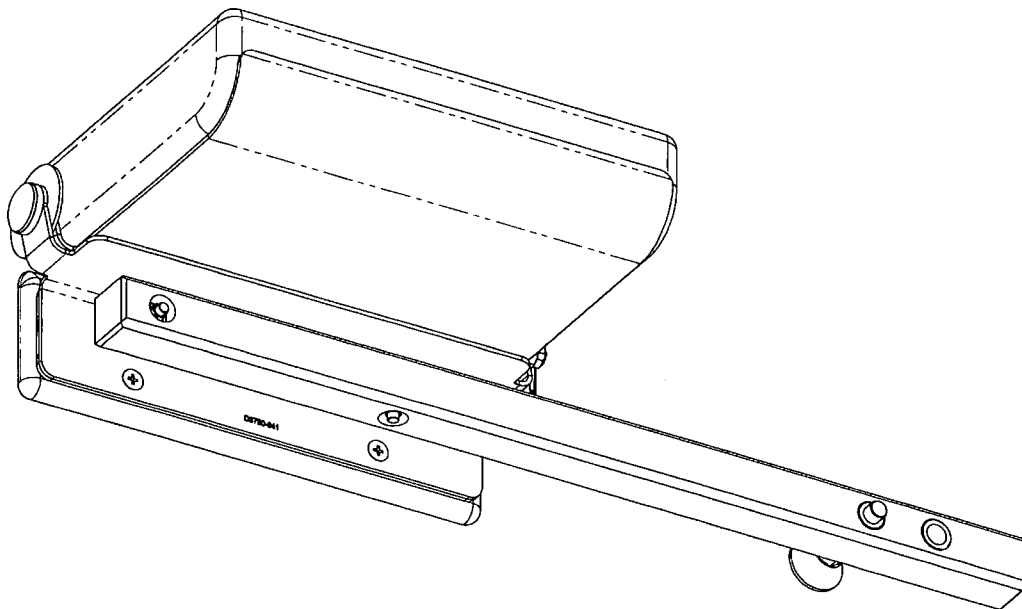
5

4

3

2

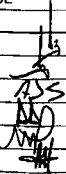
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**D3780-041 ARMREST ASSEMBLY**

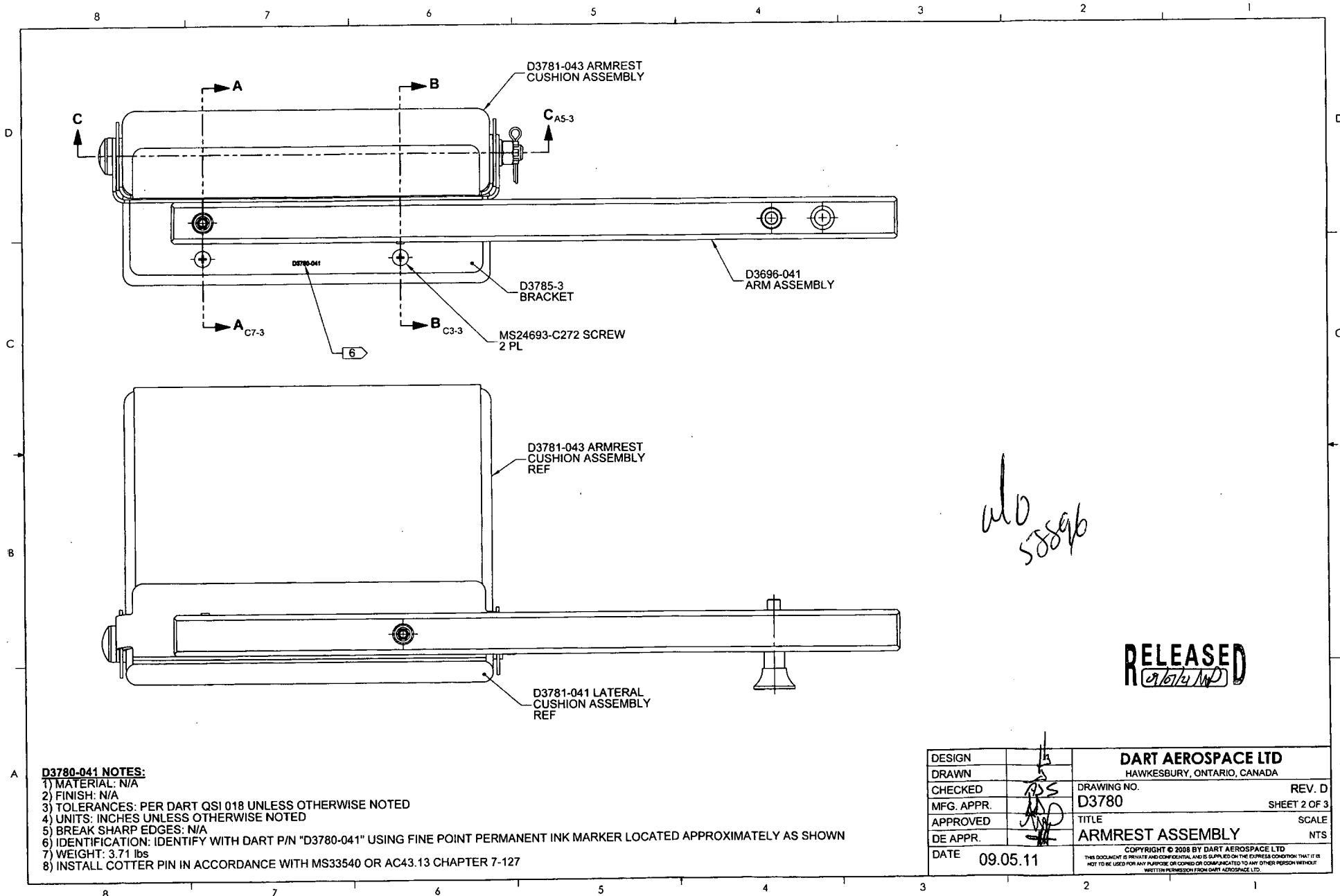
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	LATERAL CUSHION ASSEMBLY
5	1	D3781-043	ARMREST CUSHION BASE ASSY
6	1	D3785-3	BRACKET
7	1	D3977-1	BOLT (CARRIAGE), UNC
8	1	D3978-1	NUT (CASTELLATED), UNC
9	1	D3979-1	WASHER (SQUARE HOLE)
12	2	AN960JD10L	WASHER
13	2	AN970-6	WASHER
14	2	MS21042L3	NUT
15	1	MS24665-302	COTTER PIN
16	2	MS24693-C272	SCREW
17	2	MS24693-C277	SCREW
18	1	NAS1149D0663J	WASHER

W/38896

RELEASED  
07/21/14

D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 1 OF 3
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D3781-041 LATERAL  
CUSHION ASSEMBLY  
REF

D3781-043 ARMREST  
CUSHION ASSEMBLY  
REF

MS21042L3  
NUT  
AN960JD10L  
WASHER  
MS24693-C272  
SCREW  
MS24693-C277  
SCREW

**SECTION A-A** C7-2

D3781-043 ARMREST  
CUSHION ASSEMBLY  
REF

MS24693-C277  
SCREW

D3781-041 LATERAL  
CUSHION ASSEMBLY  
REF

D3785-3  
BRACKET  
REF  
AN960JD10L  
WASHER  
MS21042L3  
NUT  
MS24693-C272  
SCREW

**SECTION B-B** C6-2

AN970-6 WASHER  
2 PL

NAS1149D0663J  
WASHER

D3978-1 NUT (CASTELLATED), UNC  
MS24665-302 COTTER PIN (B)

D3785-3 BRACKET  
REF

D3977-1 BOLT (CARRIAGE), UNC

D3781-043 ARMREST  
CUSHION ASSEMBLY  
REF

D3979-1 WASHER (SQUARE HOLE)

**SECTION C-C** D5-2  
SCALE: 2X

*WLO*  
*58896*

**RELEASED**  
27/07/11

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 3 OF 3
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